

Work Order ID 69288

Friday, May 06, 2011 11:51:06 AM



Page 1

Item ID:	D3720-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	5/6/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	5/9/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3720	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3720	<input checked="" type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-					
6061 . 125	Deburr if necessary								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5 1105116

count
(42)

B11-5-13

B11-5-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69288

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Page 2

Item ID: D3720-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

C'sink as per dwg D3720

JSU/05/16 (21)

140

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

JSU/05/16

Went to
(421)
-21

150

0.00



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

21x Ø M-1405/16

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3720-2

Accept

Revision ID:

Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00

Required Date: 5/9/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

21 BL 11-5-16

170

Identify as per dwg & Stock Location: *SMR/FAB* 0.00

Packaging

Memo

0.00

Packaging

11/5/16 *[Signature]*

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/5/18 *[Signature]*

11-05-18

(21)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:51:12 AM

Page 1

Work Order ID: 69288

Parent Item: D3720-2

Parent Item Name: Step Spacer





Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			110	sf	111.9000	0.085	1.789474			
6061-T6 .125 Sheet													

B11-5-12

Location

Loc Qty

Loc Code

MAT021

111.9

113608

87.9

116700

24

113608

20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	09288
Description: Step Spacer		Part Number:	D3720-2
Inspection Dwg: D3720	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	✓		V 1807	
4.65	+/-0.030	4.660	✓		V	
2.59	+/-0.030	2.596	✓		V	
0.750	+/-0.010	.748	✓		V	
0.300	+/-0.010	.303	✓		V	
0.522	+/-0.010	.519	✓		V	
0.992	+/-0.010	.992	✓		V	
1.301	+/-0.010	1.301	✓		V	
0.731	+/-0.010	.730	✓		V	
0.888	+/-0.010	.884	✓		V	
1.771	+/-0.010	1.765	✓		V	
2.446	+/-0.010	2.447	✓		V	
0.213	+/-0.010	.213	✓		V	

Measured by:	IB	Audited by:	8	Prototype Approval:	N/A
Date:	11-5-13	Date:	11/15/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	AF

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

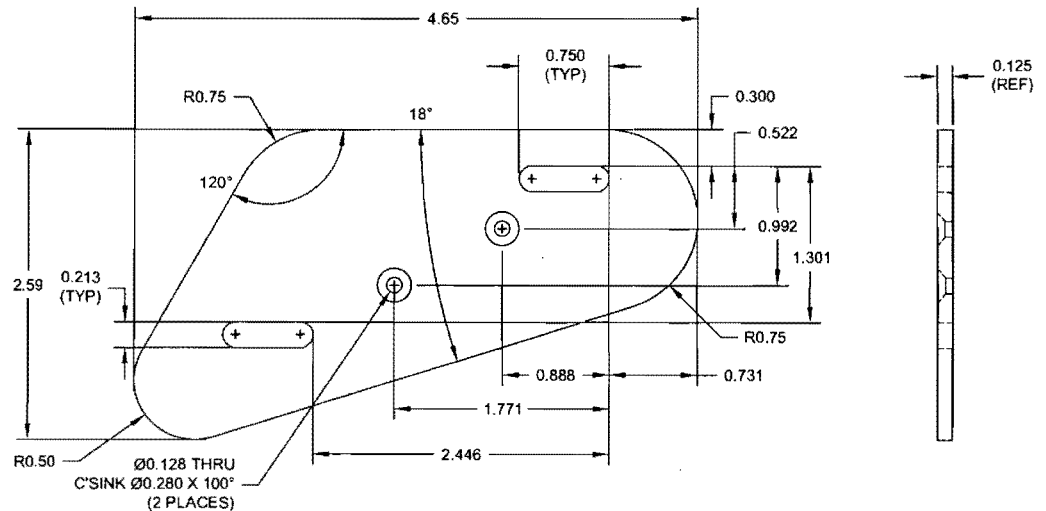
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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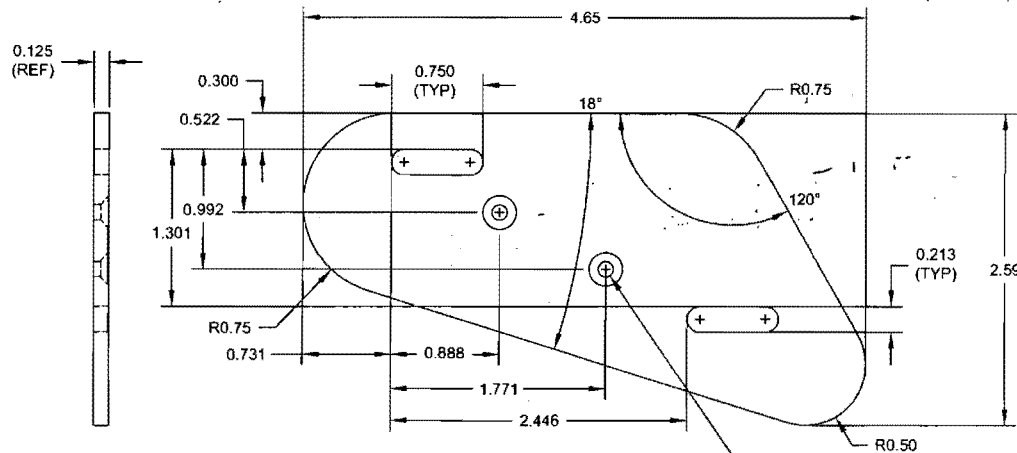
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69258*

111-05-6



D3720-1 STEP SPACER



D3720-2 STEP SPACER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

RELEASED
06-01-10

A NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>LB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>LB</i>	D3720	SHEET 1 OF 1
APPROVED	<i>LB</i>	TITLE	SCALE
DE APPR.	<i>LB</i>	STEP SPACER	1:1
DATE	07.12.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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